



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.7201

Job Sheet 210776



POSITIVE
RECALL

Part No: 650.7201

Job Qty: 5 pcs

Part Name: Bayonet Assembly



Part Weight: 0 lbs

Status: New

Job Created: 6/22/20

Job Tracking No:

Due Date: 7/15/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 650.7200 REV.PA1 IPP REV:A 20.06.19 NEW ISSUE DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE 21 9-89 AUTH JUN 22 2020

RELEASED DATE Priority: Medium

139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	5 pcs	7/15/20		0.00	0.63	Small Fab - 1		DAS 58 9-89 SEP 04 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
120	QC 5	5 pcs	7/15/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
	Packaging 3-1 - Stock - B4B	5 pcs	7/15/20		0.00	0.00	QC 5 - 50		DAS 82 9-89 SEP 14 2020
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
							Packaging 3 - 1 - B4B		

P.T.O.



Container No: S299816



Part: 650.7201

Job No: 210776

Serial No/Batch: S299816

Revision: REV.PA2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/11/20

Plex 6/22/20 2:33 PM Dart.lajeunesse.marie

				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B ✓	SEP 16 2020	DAS 80
				Packaging 3 - 4 - B4B	GA-TBD	9-89
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B	DAS	SEP 16 2020
140 QC 21 - SA	5 pcs	7/15/20	0.00 0.00	QC 21 - SA - 21	21	9-89
				QC 21 - SA - 70		
				QC 21 - SA - 9		
				QC 21 - SA - 77		

Part Op 110 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1- APPLY ITW DEVCON 14200 SERIES EPOXY (OR DESCRIPTIONS: SIMILAR) TO MATING SURFACES OF BAYONET F/N 2 AND BAYONET BODY F/N 1 ITW DEVCON 14200 SERIES EPOXY BATCH: 508606 2- ROTATIONAL ALIGNMENT OF BAYONET F/N 2 AND BAYONET BODY F/N 1 IS ARBITRARY; ACTUAL POSITION MAY VARY

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock

140 - QC21- Final Inspection - Work Order Release

NOT IN BOM.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
650.7210	Bayonet Body	5 pcs (1 ea)	110-Small Fab - 1	5087090
650.7211	Bayonet	5 pcs (1 ea)	110-Small Fab - 1	508606

5293178

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	650.7210	5	0	0
	650.7211	5	0	0

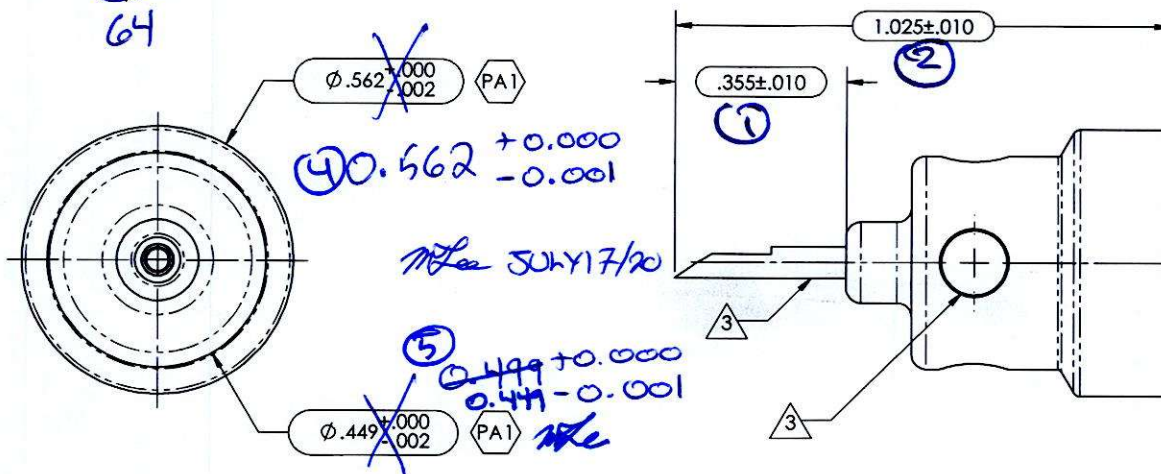
Part Specifications
Specifications could not be found.

Plex 6/22/20 2:33 PM Dart.lajeunesse.marie

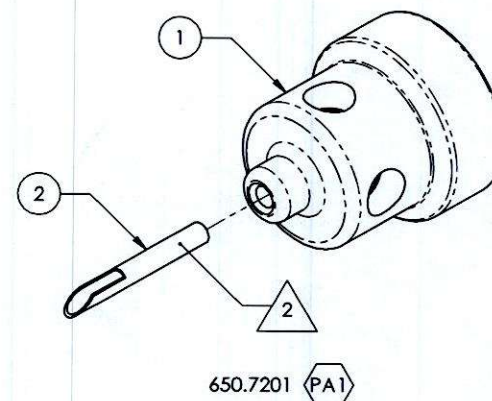
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DDA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DDA DART AEROSPACE IS PROHIBITED.

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY ITW DEVCON 14200 SERIES EPOXY (OR SIMILAR) TO MATING SURFACES OF BAYONET F/N 2 AND BAYONET BODY F/N 1
3. ROTATIONAL ALIGNMENT OF BAYONET F/N 2 AND BAYONET BODY F/N 1 IS ARBITRARY; ACTUAL POSITION MAY VARY
4. UNLESS OTHERWISE NOTED DEBURR AND BREAK ALL SHARP EDGES
5. SHARPEN BAYONET TIP FOLLOWING ELLIPTICAL EDGE
6. MATERIAL: 303 SS IAW AMS-5640
7. MATERIAL: 303 SS IAW AMS-5640 OR 304 SS IAW ASTM A908
8. FINISH 125/ MAXIMUM UNLESS OTHERWISE SPECIFIED



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04-24-2014	P. BRAVO
A	INCORPORATED ECH 05184	10-22-2015	P. BRAVO



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 210776 ML5
20-06-22

PROTOTYPE REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
B1-1 B3-1 B7-1 C3-1 A3-2 A6-2 B3-2 C5-2 C7-2 D6-3	PA1	ADDED NOTE FOR FOR 304 MATERIAL. RENUMBERED NOTES AS REQUIRED DIMENSION WAS $\phi .562 \pm .001$ IS $\phi .562 \pm .000 / .002$ P/N WAS 649.5701 IS 650.7201 DIMENSION WAS $\phi .449 \pm .001$ IS $\phi .449 \pm .000 / .002$ DIMENSION WAS $\phi .067$ IS $\phi .067 \pm .004 / .001$ DIMENSION WAS $\phi .562 \pm .001$ IS $\phi .562 \pm .000 / .002$ ADDED 60.0° DIMENSION DIMENSION WAS $\phi .449 \pm .001$ IS $\phi .449 \pm .000 / .002$ DIMENSION WAS .495 IS .480 DIMENSION WAS $\phi .249 \pm .001$ IS $\phi .249 \pm .002 / .000$ DIMENSION WAS .520 $\pm .010$ IS .52	06/01/2020	T. CROSS

1	2	650.7211	BAYONET		
1	1	650.7210	BAYONET BODY		
X		650.7201	BAYONET ASSEMBLY		
7201	FIND NO.	PART NO.	DESCRIPTION	MAT'L	SPEC
QTY					
PARTS LIST					
NEXT ASSY (S)					
650.5300					
ORIGINAL DATE 04-24-2014					
DRAWN BY CHECKER					
N/CAP P. BRAVO					
DRAWING APPROVAL					
P. BRAVO					
04-24-2014					
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED					
DIMENSIONS ARE IN INCHES					
TOLERANCES ARE:					
2 PLACE DECIMALS 1.010					
3 PLACE DECIMALS 1.005					
ANGLES 1/2°					
SIZE	CAGE CODE	DWG. NO.	REV.		
B	07M26	650.7200	PA1		
SCALE NONE				SHEET 1 OF 3	

DART 3030 ENTERPRISE CT., SUITE A
AEROSPACE VISTA, CA. 92081
APICAL INDUSTRIES, INC. (760)-724-5300
DDA DART AEROSPACE

BAYONET ASSEMBLY

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>210776</u> Part No. <u>660.7201</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date: <u>JULY 17/20</u>	Sequence #: _____	QTY Affected: <u>5</u>		MRB (QSI042) <u>SM</u> <u>20/01/17</u>	
Description Work Order Deviation		Disposition		Completed By	
<u>660.7201 HAS BEEN MANUFACTURED TO TOLERANCES HAND WRITTEN ON DRAWINGS.</u> <u>0.562 +0.000 -0.002 IS NOW 0.562 +0.000 -0.001</u> <u>0.499 +0.000 -0.002 IS NOW 0.499 +0.000 -0.001</u> <u>0.449 mda</u>		<u>UPDATED TOLERANCES ARE APPROVED</u>		Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:		<u>TOLERANCE PROMULGATIONS PER</u>			